

Date: Thursday, 17/07/2008 11:47:33 AM
 User: Julie Lecocq

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : SEAT PAN (AFT FACING LH/RH) |
| Job Number : 40587 | |
| Estimate Number : 13362 | |
| P.O. Number : | Part Number : D37741 |
| This Issue : 17/07/2008 S.O. No. : | Drawing Number : D3774 REV A B <i>08.07.19</i> |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : 11 Type : R&S THERMOFORMING | Drawing Revision : A B |
| Previous Run : 39703 | Material : |
| Written By : | Due Date : 31/07/2008 Qty: <i>5</i> Um: Each |
| Checked & Approved By : <i>JLD 08.7.17</i> | <i>+1</i> |
| Comment : Est. REV:A New Issue 08.06.04 DL verified by:DD | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---|--|------------------------------|
| 1.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
| | | |
| Comment: HAND FINISHING THERMOFORMING | | |
| Set up machine program D3774-1 | | |
| Set up clamping frame as per folio <i>OK 08.07.18.</i> | | |
| 2.0 | <i>6x</i> MLEXS125F6002904 <i>M 105330</i> | GE PLASTICS LEXAN SHEET |
| | <i>1x MLEXS 093 F600607</i> | |
| | <i>M105494</i> | |
| Comment: Qty.: 10.6670 sf(s)/Unit Total : 21.3340 sf(s) | | |
| GE PLASTICS LEXAN SHEET | | |
| Batch # <i>M 105330</i> <i>OK 08.07.18.</i> | | |
| 3.0 | HAND FINISH TH | HAND FINISHING THERMOFORMING |
| | | |
| Comment: HAND FINISHING THERMOFORMING | | |
| 1) Cut Blanks <i>6 x 32' x 44"</i> <i>OK 08.07.18.</i> | | |
| 4.0 | THERMOFORMING | THERMOFORMING MACHINE |
| | | |
| Comment: THERMOFORMING MACHINE | | |
| Thermoform as per Dwg. D3774-1 and Folio <i>e20</i> | | |
| Dwg. Rev. <i>A B OK</i> | | |
| Folio Rev. <i>A</i> <i>08.07.18</i> | | |

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|----------|------|--|-----|----------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 08.07.18 | 4 | Pull 1 additional part with MLEXSO93F600607 to be used for structural test. | Pl. | 08.07.18 | 1 | | |
| | | | | | | | |

Part No: D3774-1 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 11 Date: 08.08.21
 QA: N/C Closed: _____ Date: _____

| NCR: <u>40587</u> | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|-------------------|------|---|-----------------------------|---------------------------------|-----------------|---------------------------|----------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| 08.08.12 | 4 | Unit made with .093 Not used for Test (WHITE) | Pl 08.08.12 08.08.12 | "Scrap" & destroy | 08.08.12 Wh. | | Pl 08.08.12 08.08.12 | |
| 08.08.12 | 8 | 1 unit used for Structural test. | Pl 08.08.12 08.08.12 | Do Not Use. Retain for R+D. | Wh 08.08.12 | | Pl 08.08.12 08.08.12 | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 17/07/2008 11:47:33 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SEAT PAN (AFT FACING LH/RH)

Job Number: 40587

Part Number: D37741

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



DL 08.07.18

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

6.0

HAND FINISH TH

HAND FINISHING THERMOFORMING



Comment: HAND FINISHING THERMOFORMING

1) Trim to Finished Dimensions

BB 08/07/24

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT TRIMMED PARTS

1) Check dimensions to ensure conformity to drawing tolerances

BB 08/07/24

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

SB 08/08/15

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/19

Job Completion



MF 08-08-15

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|------------------------------------|-------|--------------|-------------|
| DART AEROSPACE LTD | | WORK ORDER: | 40587 |
| Description: Seat Pan (Aft Facing) | | Part Number: | D37741 |
| Inspection Dwg: | D3774 | Rev: | AP |
| | | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

#1
FOR
TESTING
R and D

| Description | Initials |
|---|----------|
| Acceptable shape definition | PD |
| Free of visual flaws (bumps, cracks, voids, etc.) | PD |
| | |
| | |

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing _____ Rev. __ and record below

| REVISION | Drawing | Tolerance | Actual | Accept | Reject | Method of | Comments |
|-----------|-----------|-----------|-----------|--------|--------|------------|----------|
| DIMENSION | Dimension | | Dimension | | | Inspection | |
| | 1.3" | +/- 0.100 | .123 | | | | |
| | 33.9" | +/- 0.100 | 33.9 | ✓ | | | |
| .085 | 0.100" | MIN | .87 | | ✓ | | |
| .100 | 0.135" | MIN | .111 | | ✓ | | |
| .100 | 0.135" | MIN | .111 | | ✓ | | |
| .100 | 0.135" | MIN | .111 | | ✓ | | |
| .100 | 0.135" | MIN | .121 | | ✓ | | |
| | 17.4 | MIN | 17.5 | ✓ | | | |
| | | | | | | | |
| | | | | | | | |

being revised

| | | |
|------------------------|--------------------------------|---------------------|
| Measured by: <u>PD</u> | Audited by: <u>[Signature]</u> | Prototype Approval: |
| Date: <u>05/07/24</u> | Date: <u>05/07/25</u> | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| | | New Issue | | |

| | | | |
|------------------------------------|-------|--------------|-------------|
| DART AEROSPACE LTD | | WORK ORDER: | 40587 |
| Description: Seat Pan (Aft Facing) | | Part Number: | D37741 |
| Inspection Dwg: | D3774 | Rev: | A |
| | | | Page 1 of 1 |

06.01.26

FIRST ARTICLE INSPECTION CHECKLIST

#2

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

| Description | Initials |
|---|----------|
| Acceptable shape definition | BB. |
| Free of visual flaws (bumps, cracks, voids, etc.) | BB. |
| | |
| | |

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing _____ Rev. __ and record below

| Revised Dimensions | Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------------------|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| | 1.3" | +/- 0.100 | 1.23 | ✓ | | | |
| | 33.9" | +/- 0.100 | 33.525 | ✓ | | | |
| .005 | 0.100" | MIN | .92 | | ✓ | | |
| .100 | 0.135" | MIN | 1.29 | | ✓ | | |
| .100 | 0.135" | MIN | 1.15 | | ✓ | | |
| .100 | 0.135" | MIN | 1.16 | | ✓ | | |
| .100 | 0.135" | MIN | 1.22 | | ✓ | | |
| | 12.4 | | 12.4 | | ✓ | | |
| OK | | | | | | | |
| pt | | | | | | | |

06.01.26

OK for Rev B
PM 06.01.26

| | | |
|------------------|-------------------------|---------------------|
| Measured by: BB. | Audited by: [Signature] | Prototype Approval: |
| Date: 08/07/25 | Date: 06.07.25 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| | | New Issue | | |

| | | | |
|------------------------------------|-------|--------------|-------------|
| DART AEROSPACE LTD | | WORK ORDER: | 40597 |
| Description: Seat Pan (Aft Facing) | | Part Number: | D37741 |
| Inspection Dwg: | D3774 | Rev: | A |
| | | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

#3

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

| Description | Initials |
|---|----------|
| Acceptable shape definition | BB |
| Free of visual flaws (bumps, cracks, voids, etc.) | BB |
| | |
| | |

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing _____ Rev. __ and record below

| Revised Dimensions | Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|--------------------|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| | 1.3" | +/- 0.100 | 12.8 | ✓ | | | |
| | 33.9" | +/- 0.100 | 33.875 | ✓ | | | |
| .005 | 0.100" | MIN | .87 | | ✓ | | |
| .100 | 0.135" | MIN | 110 | | ✓ | | |
| .100 | 0.135" | MIN | 113 | | ✓ | | |
| .100 | 0.135" | MIN | 114 | | ✓ | | |
| .100 | 0.135" | MIN | 115 | | ✓ | | |
| | 17.4 | | 12.4 | | ✓ | | |
| OK | | | | | | | |

OK
BB
08.03.26

OK for Rev B
BB
08.03.26

| | | |
|-----------------|-------------------------|---------------------|
| Measured by: BB | Audited by: [Signature] | Prototype Approval: |
| Date: 08/07/24 | Date: 08.08.24 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| | | New Issue | | |

| | | | |
|------------------------------------|-------|--------------|-------------|
| DART AEROSPACE LTD | | WORK ORDER: | 40587 |
| Description: Seat Pan (Aft Facing) | | Part Number: | D37741 |
| Inspection Dwg: | D3774 | Rev: | A (P) |
| | | | Page 1 of 1 |

PH 08.01.26

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

| Description | Initials |
|---|----------|
| Acceptable shape definition | BB |
| Free of visual flaws (bumps, cracks, voids, etc.) | BB |
| | |
| | |

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing _____ Rev. __ and record below

| Revised Dimension | Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-------------------|-----------|------------------|--------|--------|----------------------|----------|
| | 1.3" | +/- 0.100 | 1.23 | ✓ | | | |
| | 33.9" | +/- 0.100 | 33.875 | ✓ | | | |
| .085 | 0.100" | MIN | .07 | | ✓ | | |
| .100 | 0.135" | MIN | .121 | | ✓ | | |
| .100 | 0.135" | MIN | .112 | | ✓ | | |
| .100 | 0.135" | MIN | .110 | | ✓ | | |
| .100 | 0.135" | MIN | .118 | | ✓ | | |
| | 17.9 | | 17.9 | | ✓ | | |
| | | | | | | | |
| | | | | | | | |

OK
PH
07.01.26

OK for Rev B
PH 08.01.26

| | | |
|-----------------|-------------------------|---------------------|
| Measured by: BB | Audited by: [Signature] | Prototype Approval: |
| Date: 08/07/24 | Date: 08-07-24 | Date: |

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| | | New Issue | | |

| | | |
|------------------------------------|----------|---------------------|
| DART AEROSPACE LTD | | WORK ORDER: 40587 |
| Description: Seat Pan (Aft Facing) | | Part Number: D37741 |
| Inspection Dwg: D3774 | Rev: A B | Page 1 of 1 |

01.01.26

FIRST ARTICLE INSPECTION CHECKLIST

#5

☒ First Article ☐ Prototype

(Step 4) Thermoforming
Visual Inspection Sign-off

| Description | Initials |
|---|----------|
| Acceptable shape definition | BB |
| Free of visual flaws (bumps, cracks, voids, etc.) | BB |
| | |
| | |

(Step 6) Trimming FAI Checklist

Inspect dimensions highlighted on inspection sheet drawing _____ Rev. __ and record below

| Revised DIMENSIONS | Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-----------------------|----------------------|-----------|---------------------|--------|--------|-------------------------|----------|
| | 1.3" | +/- 0.100 | 12.47 | ✓ | | | |
| | 33.9" | +/- 0.100 | 33.875 | ✓ | | | |
| .005 | 0.100" | MIN | .90 | | ✓ | | |
| .100 | 0.135" | MIN | .171 | ✓ | | | |
| .100 | 0.135" | MIN | .162 | ✓ | | | |
| .100 | 0.135" | MIN | .130 | ✓ | | | |
| .100 | 0.135" | MIN | .152 | ✓ | | | |
| | 17.4 | | 17.4 | ✓ | | | |
| | | | | | | | |
| | | | | | | | |

OK
Rev B
01.01.26

| |
|-----------------|
| Measured by: BB |
| Date: 08/07/24 |

| |
|-------------------------|
| Audited by: [Signature] |
| Date: 08-07-24 |

| |
|---------------------|
| Prototype Approval: |
| Date: |

OK Rev B
01.01.26

| Rev | Date | Change | Revised by | Approved |
|-----|------|-----------|------------|----------|
| | | New Issue | | |



Attn: CENTAL

GE Polymershapes

1250 OLD INNES RD. 519 OTTAWA, ONT. K1B 5L3
TEL: 613 745 7043 FAX: 613 745 8163

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: 8/17/2007

YOUR PURCHASE ORDER : PO00004161

OUR SHIPPER NO: 078178

LINE ITEM # .1

QUANTITY: 81

DESCRIPTION: F60029 LEXAN GY3778 125 X 48 X 96

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH: FAR 25. 853

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

Jon Caldwell

JON CALDWELL
BRANCH MANAGER

Receiving Report

Date: 07/08/16 Batch No: M105330
 Supplier: GE Polymershapes Dart P/O: 4161

Packing Slip: Yes ☒ No ☐ Release Note Attached: Yes ☐ No ☒ N/A ☐
 Invoice: Yes ☐ No ☒ Waybill Attached: Yes ☒ No ☐
 Receipt: Cash ☐ Cr ☒ Shipment Complete: Yes ☒ No ☐ N/A ☐
 QC6 Inspection CO 07/08/16 N/A ☒
 Work Order N/A ☒

Discrepancies

| Part Number | Description | Quantity Ordered | Quantity Received | Quantity Returned | Quantity Short | Comments |
|-------------|-------------|------------------|-------------------|-------------------|----------------|----------|
| | | | | | | |
| | | | | | | |
| | | | | | | |

Initials of receiver (if shipment OK) Level 12

Production/Admin:

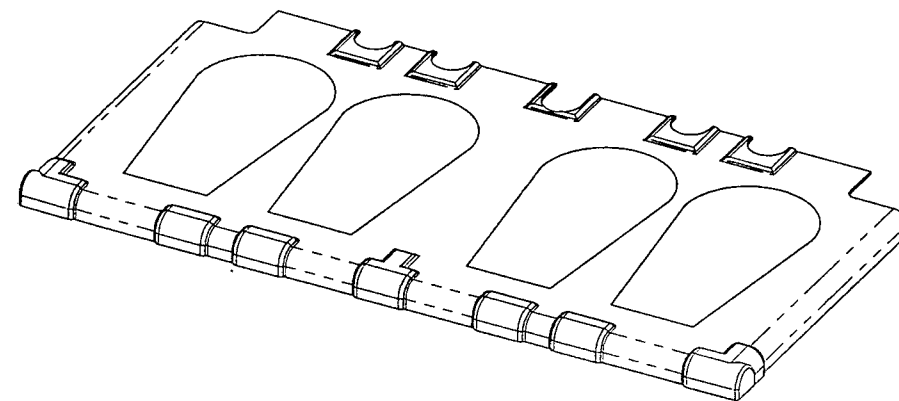
Date 07/08/16
 Received/Costing RIP 5411
 Initial CZ

Location

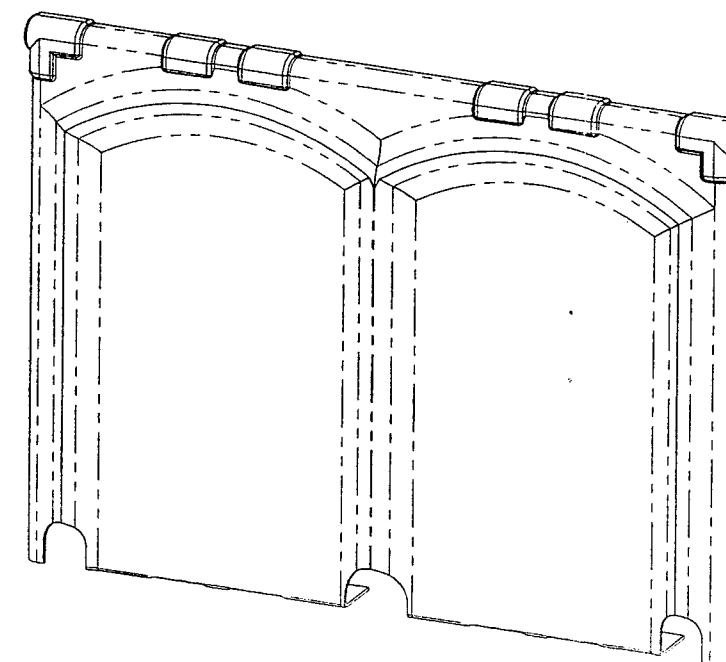
H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

** PLEASE NOTE: IF YOU WOULD LIKE TO HAVE FUTURE INVOICES FAXED OR E-MAILED TO YOU PLEASE MAIL OR FAX A COPY OF THIS INVOICE TO OUR BRAMPTON LOCATION WITH YOUR INFORMATION**
 THANK YOU
 EMAIL/FAX INFO

PLEASE Remit To: GE Polymershapes 9150 Airport Road Brampton ON L6S 6G1 Tel: 905-789-3111 Fax: 905-789-3152
 NO GOODS TO BE RETURNED WITHOUT APPROVAL FROM US. ALL DISCREPANCIES MUST BE REPORTED WITHIN 3 DAYS.



D3774-1 SEAT BOTTOM



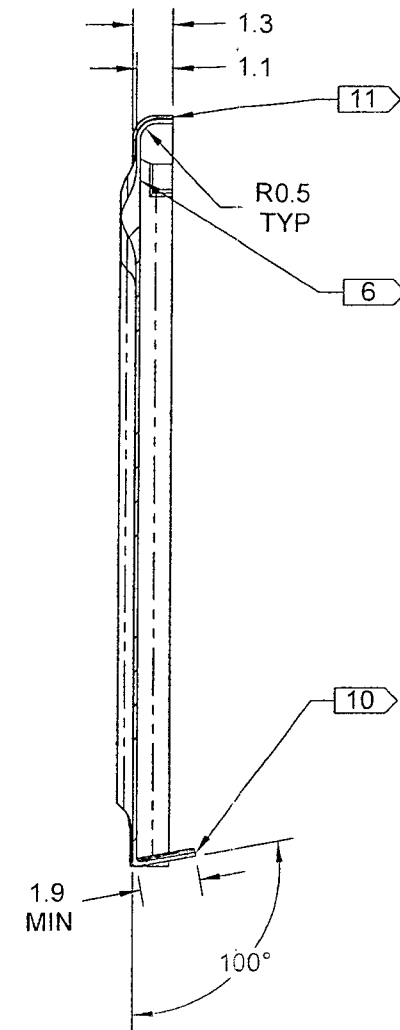
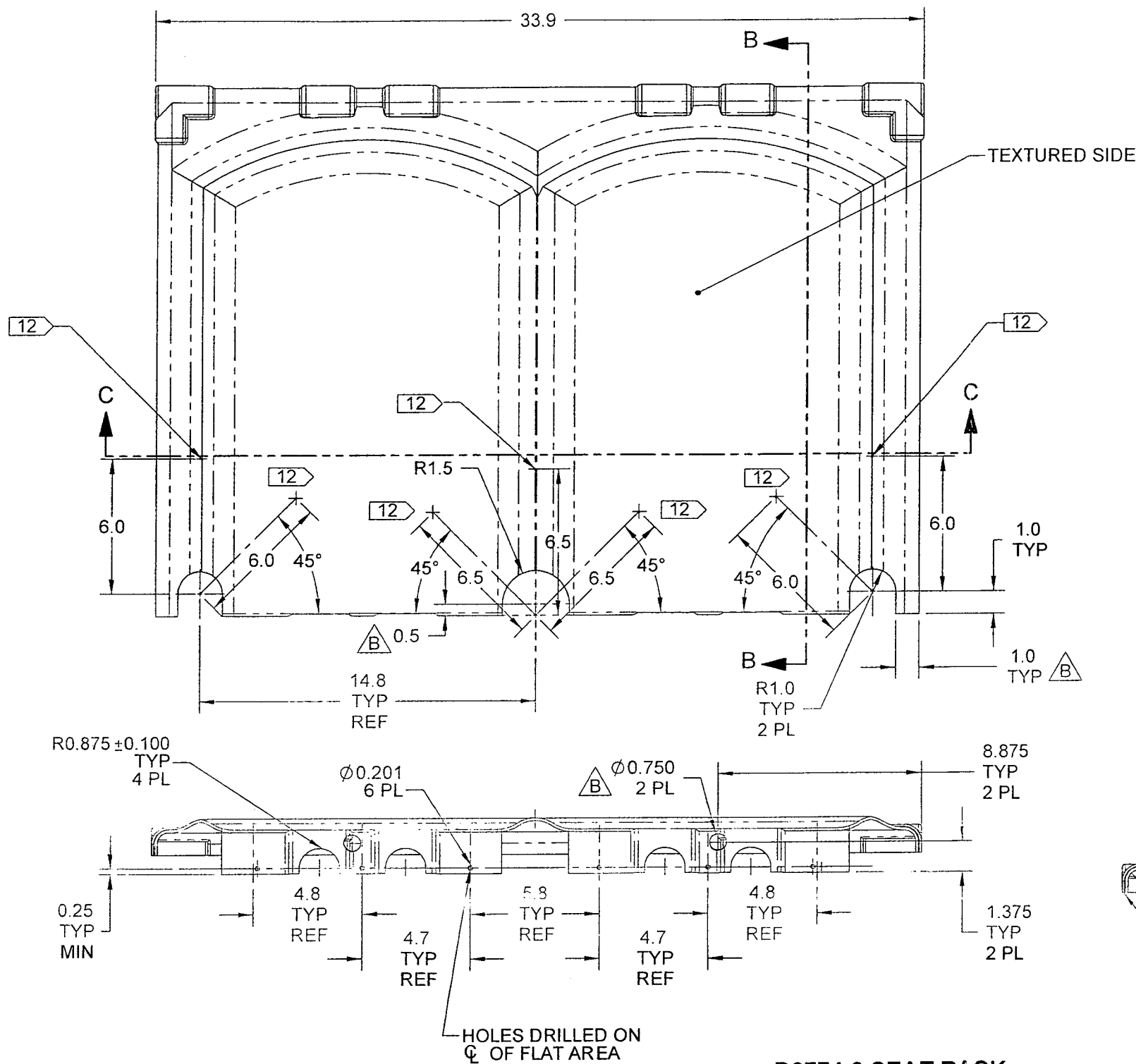
D3774-3 SEAT BACK

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 40587

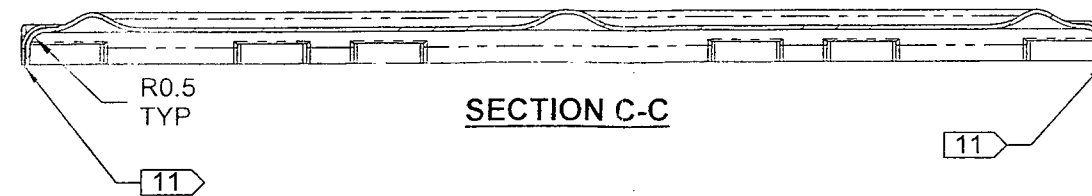
RELEASED
08-08-11/11

| | | | |
|------------|--|---|----------|
| B | UPDATE CUTOUT DIMENSIONS (ZN D4-2, D6-2, C4-3, C7-3); UPDATE MINIMUM THICKNESS (ZN A5-2, A5-3); ADD HOLES ON D3774-3 (ZN B6-3) REASON: MANUFACTURING CAPABILITIES | PH | 08.07.25 |
| A | NEW ISSUE | HS | 08.06.23 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | HS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3774 REV. B SHEET 1 OF 3 TITLE SEAT SCALE NTS DATE 08.07.25 | |
| DRAWN | PH | | |
| CHECKED | PH | | |
| MFG. APPR. | PH | | |
| APPROVED | PH | | |
| DE APPR. | PH | COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |

8 7 6 5 4 3 2 1



SECTION B-B



SECTION C-C

SHOP COPY
RETURN TO
ENGINEERING
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40587

D3774-3 SEAT BACK

RELEASED
08-05-11

- NOTES:
- 1) MATERIAL: F60029 GREY LEXAN SHEET (HEAVY HAIRCELL TEXTURE) 0.125" THICK TEXTURED SIDE UP (REF. DART SPEC MLEXS.125-F60029-04)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3774-3" USING VIBRATING STYLUS
 - 7) WEIGHT: 4.82 lbs
 - 8) PART TO BE PRODUCED FROM MOLD DT9023 AND PER DART QSI 022
 - 9) OVERALL DIMENSIONS GIVEN ONLY FOR FURTHER INFORMATION REFER TO MOLD DT9023
 - 10) MINIMUM MATERIAL THICKNESS AFTER FORMING ON BOTTOM FLANGE IS 0.065
 - 11) MINIMUM MATERIAL THICKNESS AFTER FORMING FLANGES (WITHIN 2.0 FROM EDGES) IS 0.085
 - 12) MINIMUM MATERIAL THICKNESS AFTER FORMING AT THESE POINTS IS 0.100

| | | | |
|------------|----------|---|--------------|
| DESIGN | HS | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | PA | | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3774 | SHEET 3 OF 3 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | SEAT | NTS |
| DATE | 08.07.25 | COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD | |